



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

NCR-19-7712

C250-200

Job Sheet 200686



Part No: C250-200

Job Qty: 3 pcs

Part Name: Side Plate Housing



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/16/19

Job Tracking No:

Due Date: 11/1/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG C250-200 REV:3 IPP REV A 18.02.27 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Machining - Issue SN	3 pcs	11/1/19	11/1/19	0.00	0.00	NV5000 - 1		J.C. 19-10-20
							NV5000 - 2		
110	NV5000 - 1	3 pcs	11/1/19	11/1/19	1.00	9.09	NV5000 - 1		
							NV5000 - 1 - B4B		
							NV5000 - 2		
							NV5000 - 2 - B4B		J.C. 19-10-30
120	QC 2	3 pcs	11/1/19	11/1/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		J.C. 19-10-30
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		



Container No: S224413



Part: C250-200

Job No: 200686

Serial No/Batch: S224413

Revision: 3

Inspector:

Exp Date:

Instructions:

Date: 10/21/19

PTO →

130 QC 8	3 pcs	11/1/19	0.00 0.00	QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	2019/11/01
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
150 Outsource - 4 - Anodize	3 pcs	11/1/19		GRO002-VC	10 2019-11-04
160 Packaging 2-1 - Receive - B4B	3 pcs	11/1/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	NOV 13 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	

170 QC 6	3 pcs	11/1/19	0.00 0.00	Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				QC 6 - 9	DAS
				QC 6 - 68	NOV 13 2019 68
				QC 6 - 61	9-89
				QC 6 - 40	
185 Packaging 3-1 - Stock - B4B	3 pcs	11/1/19	0.00 0.00	QC 6 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS
				Packaging 3 - 7 - B4B	58
				Packaging 3 - 8 - B4B	9-89
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	3 pcs	11/1/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89

Part Op 110 - NV5000-1 (MORI SEIKI VERTICAL MACHINE #1) - 1-Machine as per folio FC007 FOLIO REV: AA
 Descriptions: DWG REV: 3 2-Debur
 120 - QC2- Inspect parts off machine FAI/FAIB - Engrave S/N Using Marktronic engraver. See note 1 for location.
 130 - QC8- Inspect parts - second check
 150 - -Issue P/O to ATG: 44998 -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required
 160 - Receive & Inspect for Damage & Mat'l Certs
 170 - QC6- All purchased or subcontracted products
 185 - Identify as per dwg & Stock Location: FA203F
 190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S2.250X13.500	6061-T6 Sheet 2.250" Thick x 13.500" Wide cut to size: 16.750"	3 Ea (1 ea)	100-Machining - Issue SN	8217180

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Machining - Issue SN	M6061T6S2.250X13.500	3	11	0
Part Specifications				
Specifications could not be found.				

Plex 10/21/19 8:14 AM DART.CHAREST-LACOMBE.JULIEN

DART AEROSPACE LTD		Work Order: 200686
Description: Side Plate Housing		Part Number: C250-200
Inspection Dwg: C250	Rev: 3	Page 1 of 1

INSPECTION SHEET

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
	16.36	± 0.010	16.365	✓		Caliper	A 1000
	13.15	± 0.010	13.150	✓			
	Ø 1.25	± 0.010	1.280	✓			JCL-08
(DI)	Ø 1.00	± 0.010	1.000	✓			
	6.763	± 0.005	6.763	✓		NV-Scot-2	
	4.721	± 0.005	4.7215	✓		"	
	Ø .9358	± 0.0005 ± 0.0006	Ø .9358	✓		Wire Gauge	
(E)	.081	± 0.005	0.081	✓		NV-Scot-2	
	5.980	± 0.005	5.980	✓		"	
(J)	Ø 0.6244	± 0.0004 ± 0.0005	Ø .6245	✓		Wire Gauge	
	1.111	± 0.005	1.111	✓		NV-Scot-2	
	7.831	± 0.005	7.831	✓		"	
	Ø 1.001	± 0.010 ± 0.011	1.0015	✓		Mic.	JCL-001
	1.165	± 0.010 ± 0.011	1.165	✓		Caliper	JCL-08
(K)	1.145	± 0.005 ± 0.006	1.140	✓			
	9.717	± 0.005	9.712	✓		NV-Scot-2	
	2.207	± 0.005	2.207	✓		NV-Scot-2	
	0.684	± 0.005 ± 0.006	0.684	✓		Mic.	JCL-01
	1.0.915	± 0.010 ± 0.011	0.915	✓		Caliper	JCL-08
(L)	1.155	± 0.005	1.157	✓		Caliper	
	Ø 1.501	± 0.000 ± 0.001	1.5004	✓		Mic.	JCL-08
	1.725	± 0.010 ± 0.011	1.730	✓		Caliper	JCL-08
	1.145	± 0.005 ± 0.006	1.147	✓			
(M)	Ø .188	± 0.005 ± 0.006	.1875	✓			
	1.685	± 0.005	1.685	✓			
	2.020	± 0.005 ± 0.006	2.022	✓		Mic.	JCL-02
	1.000	± 0.004 ± 0.005	1.060	✓		Caliper	JCL-08
	1.188	± 0.004 ± 0.005	1.188	✓			
	.230	± 0.005	.231	✓			
	Ø 2.815	± 0.010 ± 0.011	2.815	✓			
	Ø 4-28 UNF	2B	Ø .K.	✓		60 NV-60	
	3.750	± 0.005	3.750	✓		Caliper	JCL-08

Measured by: J.C.V.	Checked by: [Signature]	QC Inspector:
Date: 19-10-24	Date: 19/11/01	Date:

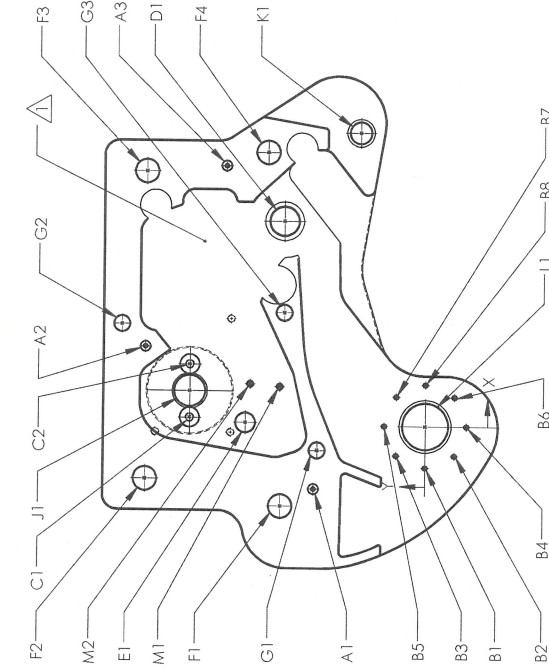
Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

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TAG	XLOC	Y LOC	SIZE	
A1	-2.088	3.700	$\varnothing$.156 THRU ALL └┐ $\varnothing$.316 ▽ 1.125 .02 X 45°	
A2	2.560	9.310		
A3	8.600	6.656		
B1	-1.368	-.000		
B2	-.967	-.967		
B3	-.967	.967	10-32 UNF - 2B THRU ALL	
B4	.000	-1.368		
B5	-.000	1.368		
B6	.967	-.967		
B7	.967	.967		
B8	1.368	.000	$\varnothing$.250 THRU ALL .02 X 45° FAR SIDE └┐ $\varnothing$.625 ▽ 1.460 .02 X 45° NEAR SIDE	
C1	.236	7.831		
C2	1.986	7.831		
D1	6.763	4.721		$\varnothing$.9363 THRU ALL $\varnothing$.9358 THRU ALL .04 X 45° NEAR SIDE └┐ $\varnothing$ 1.290 ▽ 1.145 ^{+.003} -.000
E1	.081	5.980		
F1	-2.659	4.796	$\varnothing$.6248 THRU ALL .03 X 45° NEAR SIDE	
F2	-1.793	9.299		
F3	8.407	9.299		
F4	9.055	5.274		
G1	-.817	3.592		
G2	3.307	10.093	$\varnothing$.750 THRU ALL 2X .03 X 45°	
G3	3.712	4.709		
J1	1.111	7.831		
K1	9.717	2.207	$\varnothing$ 1.001 THRU ALL .03 X 45° NEAR SIDE └┐ $\varnothing$ 1.165 ▽ 1.145 ^{+.003} -.000	
L1	.000	.000		
M1	1.269	4.843	$\varnothing$.689 ^{+.000} -.002 THRU ALL 2X .03 X 45° └┐ $\varnothing$.915 ▽ 1.155	
M2	1.356	5.828		
			$\varnothing$ 1.501 ^{+.000} -.001 THRU ALL .03 X 45° NEAR SIDE └┐ $\varnothing$ 1.728 ▽ 1.145 ^{+.003} -.000	
			$\varnothing$.188 ▽ 1.685 .02 X 45° NEAR SIDE	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C250-200	1	SIDE PLATE HOUSING	6061	2.18 X 1.32 X 1/4 X 1/2



NOTE:

NOTE:  MACHINE ENGRAVE BATCH NUMBER.



SIDE PLATE HOUSING

DWG NO.	C250-200	REV	3
MATL	6051	DRAWN BY:	APICAL
UNLESS OTHERWISE SPECIFIED	APPROVED		
DIMENSIONS ARE IN INCHES	REAR		
XXX ± .005 FRACTIONS ± 1/16	FRONT		
XX ± .01 ANGLES ± .1°	RIGHT		
X ± .1	BLACK ANODIZE		
1. BREAK ALL SHARP EDGES .015 X 45°	BPFC MIL-A-8625F TYPE II CLASS II		
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL		
SCALE	1:4	DATE	6/13/2011
			SHEET 1 OF 2

2-18 X 13-1/4 X 16-1/2

DATE	6/12/2014	CIF
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ET 4 OF 5

REV	ECR	REVISIONS		
		DESCRIPTION	DATE	INITIAL
1		CHD ET HOLE TOLERANCE WAS 0.027 - 0.029 - 0.01 IS 0.026-0.024	6/28/2013	CF5
2		CHD ET HOLE CHAMFER WAS 0.0 X 15° R 0.3 X 45°	8/20/2013	CF5
3	14-01-26	CHD WAS (13.511) IS (13.15), WAS (16.361) IS (16.36), WAS (3.50) IS 3.50, DELETED DIM Ø 9.15, ADDED OFF NOTE	8/1/14	DPD
				EW



PART AEROSPACE

SIDE PLATE HOUSING

DWG NO.	C250-200	REV	3
MAT'L	6061	DRAWN BY:	APICAL
UNLESS OTHERWISE SPECIFIED		APPROVED	<i>P. Mui</i>
ALL DIMENSIONS ARE IN INCHES		FEAT	
.XXX ± .001	FRACTIONS ± 1/8	FINISH	BLACK ANODIZE
.XX ± .01	ANGLES ± 5°		
.X ± .01		SPEC	MIL-A-8825F, TYPE II, CLASS II
ALL DIMENSIONS SHALL SHARP EDGES .015 ± .015"			USED ON MODEL
OR OTHER			

PLATING		
SCALE	1:4	DATE 6/13/2011
		SHEET 2 OF 2



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044998



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044998

PO Date: 11/4/19

Due Date: 11/12/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-11-05

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	200686	C250-200	C250-200 Rev 3	Side Plate Housing -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	11/12/19	3 pcs	0 pcs	3 pcs	\$58.50/pcs	\$175.50
2	200685	C250-100	C250-100 Rev 4	Side Plate Cover -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	11/12/19	3 pcs	0 pcs	3 pcs	\$58.50/pcs	\$175.50
Grand Total:												\$351.00

DAS
68
9-89

NOV 13 2019

NOV 13 2019

Guerin



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044998



Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/5/19 1:13 PM Dart.Guerin.Kimberley

**Certificat de Conformité / Certificate of Compliance**
(023817-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupealtech.com

Bon de Livraison / Packing Slip**023817 - 1**

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
08-Nov-2019		Jigar Patel		POHB044998					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap	À venir / Back Order	
1	C250-200 Rev.	C250-200 01-ANO-BLACK [ANODIZE BLACK] AS PER IAW MIL-A-8625F TYPE - 2, CLASS - 2 WATER SEALANT	ANODIZE CH	3	3	0	0	0	
2	C250-100 Rev.	C250-100 01-ANO-BLACK [ANODIZE BLACK] AS PER IAW MIL-A-8625F TYPE - 2, CLASS - 2 WATER SEALANT	ANODIZE CH	3	3	0	0	0	

RECEIVED

NOV 12 2019

DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual ThicknessInspecteur Qualité
Quality InspectorRéçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.

Entered:

Date:

11/18/91

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

19-7772

Route update only ☐

Job: 200 686		DISPOSITION		DEPARTMENT/PROCESS				Engineering	
Part No. C230-200		Rework ☐ Scrap ☒ Use-as-is ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging		Water Jet ☐ Supplier ☐ Quality ☐	
Date: 19-10-25	Sequence #: 110	QTY Affected: 2		DART (QS1042) 51 19/10/90 9-89					
Description Work Order Deviation				Disposition					
1- The reamers were oversized holes operator manually program with a end mill and one lead-out was wrong. Ø 0.8935 is not round. 2- When adjusting off-set, operator write (.0002") instead of (.0002"). Ø 0.894 is at Ø 0.8935"				Scrap and replace					
Completed By J.C. L. 19-10-25				Lead hand / Supervisor Duff 19/11/01					
QC / QA Coordinator DAS 9 9-89 19-11-31									
Root Cause				FAULT CATEGORY					
Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☒					
Other/Details:				Positioned Wrong ☐ Outside Tolerance ☒ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐					